

Work Order ID 133640

Monday, June 15, 2015 10:10:22 AM

133640

Page 2

Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Float Web (206L/407)
Start Date: 6/15/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/15/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130						10			15/06/30
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						10		15-7-6	J/DEL
HandFinish	Memo	0.04							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						10	0	15-7-6	
QC	Memo	0.00							
Quality Control									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes					10	0	15-7-9	DGL
Skidtubes	Memo	0.04							
Skidtubes	1-Install doublers as per Dwg D3282.								
170		0.00							
170	QC5- Inspect part completeness to step on W/O	0.00				10	0	15-7-9	
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Identify as per dwg & Stock Location: <u>LG002</u>	0.00				10	0	15-7-9	DGL
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							JUL 14 2015
190									
QC	Memo	0.02							
Quality Control									

MLJ JUL 14 2015

Picklist Print

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Work Order ID: 133640

133640

Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 6/15/2015

Required Date: 6/15/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM IPP REV:C 11.09.20
remove LPS as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130		Manufactured	No			100	Each	81.0000	1	10			

D2792-130

EXTRUSION

Location	Loc Qty	Loc Code
HALL	81	
112219	29	
128109	52	

10

Doc 15-6-15.

D3283-1

Manufactured No

160

Each

77.0000

2

20

D3283-1

Doubler

Location	Loc Qty	Loc Code
LG001	77	
126289	77	

20

Doc 15-7-6.

MS20470AD4-7

Purchased No

160

Each

681.0000

57

570

MS20470AD4-7

Rivet, Universal Head

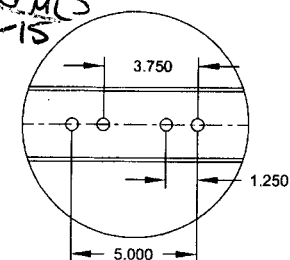
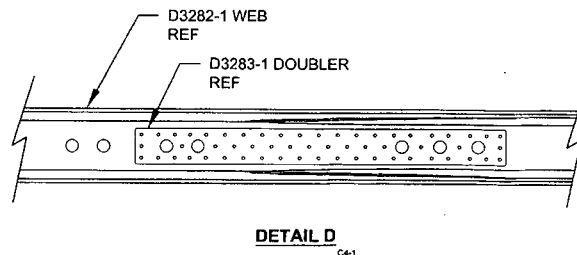
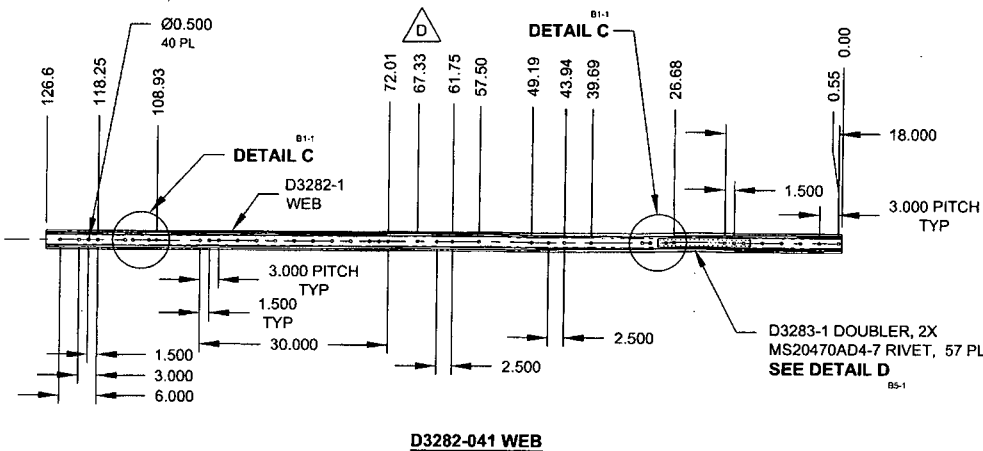
Location	Loc Qty	Loc Code
LG002	21	
* m128228	21	
ST310	660	
L6052 123525	660	

508

Doc 15-7-6.

482

Doc 15-7-9.



NOTE: RIVET HOLES/DOUBLER NOT SHOWN FOR CLARITY

RELEASED
2011-09-12

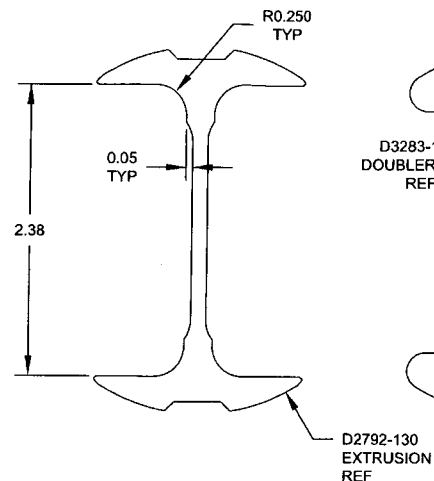
NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

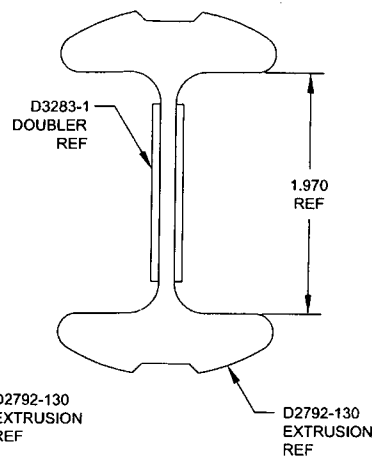
D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3282	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

SECTION A-A

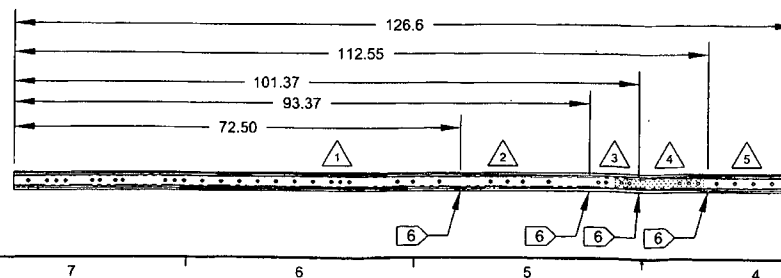


SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. D
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	133 640
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		SL01	Tape
1.500	+/-0.010	1.500	✓	CNC-02		
3.000	+/-0.010	3.000	✓	"		
6.000	+/-0.010	6.000	✓	"		
1.250	+/-0.010	1.250	✓	"		
30.000	+/-0.010	30.000	✓		SL01	
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.010	✓			
61.75	+/-0.030	61.750	✓			
57.50	+/-0.030	57.500	✓			
49.19	+/-0.030	49.190	✓			
43.94	+/-0.030	43.940	✓			
39.69	+/-0.030	39.690	✓			
26.68	+/-0.030	26.680	✓		CNC-02	12" VERN
0.55	+/-0.030	0.545	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.380	✓			
0.05	+/-0.030	0.050	✓			

Measured by:	DAS 20 9-89
Date:	1506-24

Audited by:	DAS 14 9-89
Date:	1506/30

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐	☐	Positioned Wrong ☐															
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐															
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐															
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐															
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐															
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐															
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐															
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐															
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐															
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐															
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							